

Work Order ID 103595-1

\*103595\*

Page 1

June-24-13 1:59:00 PM

Item ID: D3709-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Angle

Start Date: 6/24/13

Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 7/05/13

Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals:

Process Plan: M15

Date: 130625

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3709	Rev A								

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709Dwg Rev: A Prog Rev: A

6061-063

\*\*\*\*grain direction on a 45 degree\*\*\*\* 2- Deburr if necessary

4 0 Ac 13.08.0  
2nd wt 4 0 Jm 13-09-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

4 0 Ac 13.08.0  
2nd wt 4 0 Jm 13-09-5

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

27  
13-8-7  
1395

4

4





# Work Order ID 103595

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June-24-13 1:59:00 PM

Item ID: D3709-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Angle  
 Start Date: 6/24/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 7/05/13 Req'd Qty: 2.00 \*2\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				1			PTO 3/6/09/06
Small Fab	Memo Form as per dwg D3709	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				1			
Quality Control	Memo	0.00							DAS 27 9-89 B9.6
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				1			
Hand Finishing	Memo	0.00							WG 139-6





Work Order ID 103595

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Item ID: D3709-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Angle

Start Date: 6/24/13

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/05/13

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

27

\*160\*

QC

Memo

0.00

139.6

Quality Control

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

\*170\*

Packaging

Memo

PPP 106472

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

13/6/9

MF  
13-6-9

30

# Picklist Print

June-24-13 1:59:00 PM

Page 1

Work Order ID: 103595

Parent Item: D3709-3

Parent Item Name: Angle

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No				sf	546.4938		0.56	.56	A	13.08.07

Location

Loc Qty

Loc Code

MAT021

546.4938

123135

120.2625

124003

79.19

125431

11.0413

M126075

336

126075











103595 MJS  
1306-25

**D3709-3 ANGLE**

**D3709-1 ANGLE**

**RELEASED**  
29/04/97

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs  
D3709-3 = 0.16 lbs

REV.	NEW ISSUE	DESCRIPTION	MB	08.05.02
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.02			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

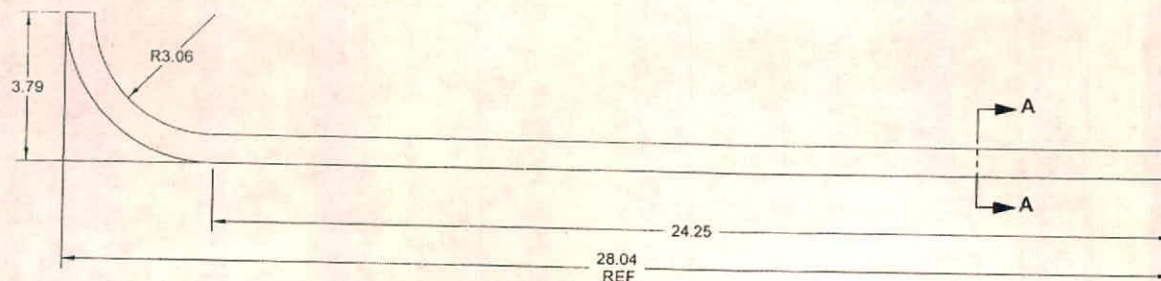
DRAWING NO. **D3709** REV. A  
TITLE **ANGLE** SHEET 1 OF 3  
SCALE NTS

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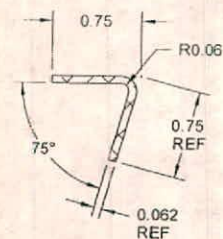




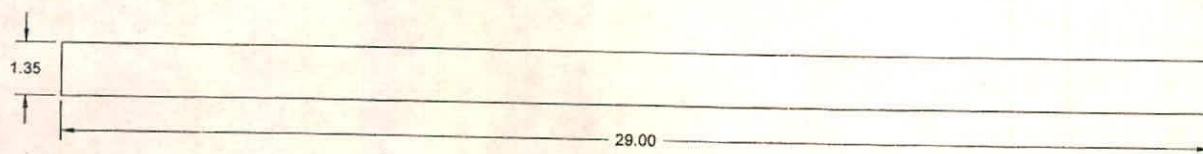
103595



**D3709-1 ANGLE**  
(MAKE FROM D3709-1F)



**SECTION A-A**  
SCALE 2X



**D3709-1F ANGLE FLAT PATTERN**

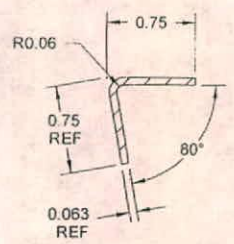
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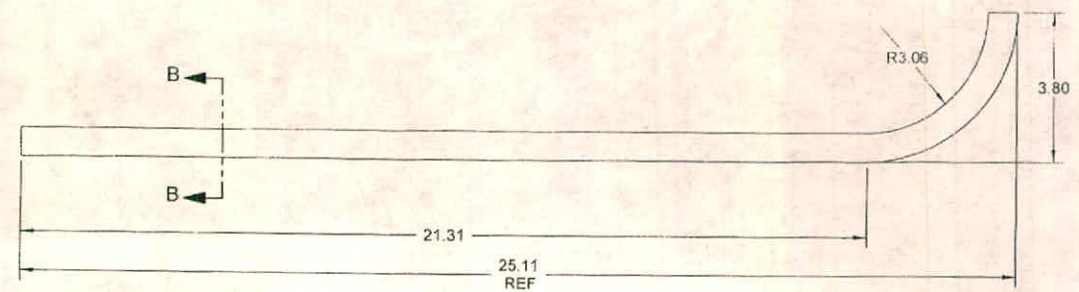




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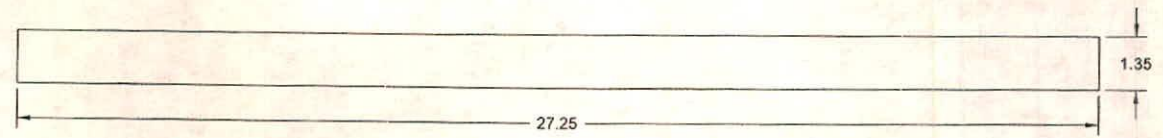


**SECTION B-B**  
SCALE 2X



**D3709-3 ANGLE**  
(MAKE FROM D3709-3F)

GRAIN  
DIRECTION



**D3709-3F ANGLE FLAT PATTERN**

**RELEASED**  
07/04/09

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8 7 6 5 4 3 2 1

